

Work Order ID 133722

133722

Page 1

Tuesday, June 16, 2015 10:54:17 AM

Item ID: PB67-43001-11 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Fwd Adjustable Blade Support Assembly
 Start Date: 6/16/2015 Start Qty: 3.00 *3* Cust Item ID:
 Required Date: 6/16/2015 Req'd Qty: 3.00 *3* Customer:
 Reference:

Approvals: Process Plan: MCS Date: JUN 17 2015 Tooling: _____ Date: _____
 QC: _____ Date: JUN 17 2015 SPC (Y/N): _____ Date: _____
 Run Start *NR1*
 Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
B67-43001-11	Rev C

100 Large Fab 0.00
 100 Large Fab Memo 0.00
 Large Fab 1- make a 0.090" chamfer in the 1.00" hole before welding
 2- assemble parts and weld as per dwg
 3- grind weld flush in area of PB67-43001-249 only

3- 400
 JUL 29 2015 DAS
 24
 9-89

P.T.O.

110 QC9- Inspect visual per QSI004- Fusion Welds 0.00
 110 QC Memo 0.00
 Quality Control

② 15-07-31 DAS
 9
 9-89

DQA: Just Date: 15/08/24

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: BAA Date: 15/08/20Work Order update only ☐

Work Order: <u>133722</u> Part No. <u>PB6743001-11</u> NCR No. <u>15-5255</u>	DISPOSITION Rework ☒ Scrap ☒ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☒</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☒	Composite ☐	Supplier ☐																																																
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crack found after welding. in PB67-43001-67 RC. Process		Scrap + destroy PB67-43001-67 B134790 B92092 Replace with B134790		DAS Completed By 24 JUL 31 2015 9-89																																																																
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133722

Page 2

Item ID: PB67-43001-11

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Fwd Adjustable Blade Support Assembly

Start Date: 6/16/2015 Start Qty: 3.00

3

Cust Item ID:

Required Date: 6/16/2015 Req'd Qty: 3.00

3

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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115

115

Mill Conv

Memo

Conventional Milling Machine

TAP AND INSTALL HELICOIL

0.00

0.00

3	JUL 31 2015	DAS 24 9-89
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120

120

QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

③	15-07-31	DAS 9 9-89
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150

150

HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

Memo

DAS

9

9-89

0.00

0.00

DAS

9

9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		OTHER : _____					

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Page 3

Item ID: PB67-43001-11 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Fwd Adjustable Blade Support Assembly
Start Date: 6/16/2015 Start Qty: 3.00 ***3*** Cust Item ID:
Required Date: 6/16/2015 Req'd Qty: 3.00 ***3*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* Powdercoat Powder Coating	Green Sandtex(Ref:4.3.5.8) per QSI005 4.3 Memo 1- MASK TUBE FROM BASE TO GUSSET START TIME: 9:00 AM OVEN TEMPERATURE: 320°F FINISH TIME: 9:30 PM 1111 211	0.00 0.00				3x	4	22	13/08/08
170 *170* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				(3)			DAS 38 AUG 10 2015
180 *180* Small Fab Small Fab	Small Fab Memo 1- match drill cover to existing holes in support 2- assemble as per dwg	0.00 0.00				3x			DAS 36 15/08/14

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
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Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
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Past Expiry Date ☐	Manufacturing Process ☐				
Misidentified ☐	Past Due ☐	OTHER : _____			

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

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OTHER :																																																																					

Picklist Print

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Page 1

Work Order ID: 133722

133722

Parent Item: PB67-43001-11

PB67-43001-11

Parent Item Name: Fwd Adjustable Blade Support Assembly

Start Date: 6/16/2015

Required Date: 6/16/2015

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP Rev:A 08-06-26 new issue DD verified by:ec
10.09.27 per revC dwg EC verified by:DD

IPP Rev B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
PB67-43001-67		Manufactured	No				Each	1.0000		3			
PR67-43001-67 90° Blade Support Assembly													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA004		1							
				92092		1							
PB67-43001-247		Manufactured	No			100	Each	4.0000	1	3			
PR67-43001-247 Inner Tube													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				Mezz2		4							
				115355		4							
PB67-43001-249		Manufactured	No			100	Each	5.0000	1	3			
PR67-43001-249 Inner Tube Bushing													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA003		5							
				133229		5							
PB67-43001-253		Manufactured	No			100	Each	7.0000	1	3			
PR67-43001-253 Gusset													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				Mezz2		7							
				116441		2							
				133228		5							

**

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**

**

DAS
24
8-89

~~STW 8-8-10~~
JUL 28 2015
B134790 → 1 ←

X3 MF 15-7-15

MF 15-7-13

MF 15-7-13

3x 133727 MF 15-7-13

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐				

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Page 2

Work Order ID: 133722

133722

Parent Item: PB67-43001-11

PR67-43001-11

Parent Item Name: Fwd Adjustable Blade Support Assembly

Start Date: 6/16/2015

Required Date: 6/16/2015

Start Qty: 3.00

Required Qty: 3.00

PB67-43001-254

Manufactured No

100

Each

5.0000

1

3

PR67-43001-254

Gusset

Location

Loc Qty

Loc Code

Mezz2

5

133227

5

MS124780

Purchased

No

180

Each

77.0000

1

3

MS124780

HELICAL INSERT

Location

Loc Qty

Loc Code

ST260a

60

m128173

60

ST317

17

111064

17

MS27039-1-10

Purchased

No

180

Each

362.0000

8

24

MS27039-1-10

SCREW

Location

Loc Qty

Loc Code

CA

41

m128635

41

GA

239

m129541

239

ST285

82

m123522

2

m130358

70

m130388

10

MF 15-7-12

MF 15-8-17

15/08/14 DAS 36 9-89

24

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
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				Lead hand / Supervisor Approval Verification	
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Root Cause		FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
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LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐				
Misidentified ☐	Past Due ☐	OTHER : _____			

Picklist Print

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Page 3

Work Order ID: 133722

133722

Parent Item: PB67-43001-11

PB67-43001-11

Parent Item Name: Fwd Adjustable Blade Support Assembly

Start Date: 6/16/2015

Required Date: 6/16/2015

Start Qty: 3.00

Required Qty: 3.00

NAS1149D0316J

Purchased

No

180

Each

345.0000

8

24

NAS1149D0316.1

Washer

15/08/14
DAS
36
9-89

Location

Loc Qty

Loc Code

GA

132

122151

132

ST270

213

M127956

213

NAS1149D0363J

Purchased

No

180

Each

1,765.000

8

24

NAS1149D0363.1

Washer

15/08/14
DAS
36
9-89

Location

Loc Qty

Loc Code

CA

569

m130799

569

GA

182

m128429

182

ST269

1014

m126319

7

m131618

7

m132317

1000

PB67-43001-69

Manufactured

No

180

Each

10.0000

1

3

PB67-43001-69

90 Degree Cover Plate

Location

Loc Qty

Loc Code

Mezz2

10

111761

10

MF 15-7-13

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Page 3

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																		
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								Lead hand / Supervisor Approval Verification																	
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Past Expiry Date ☐	Manufacturing Process ☐																								
Misidentified ☐	Past Due ☐	OTHER : _____																							

Picklist Print

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Work Order ID: 133722

133722

Parent Item: PB67-43001-11

PB67-43001-11

Parent Item Name: Fwd Adjustable Blade Support Assembly

Start Date: 6/16/2015

Required Date: 6/16/2015

Start Qty: 3.00

Required Qty: 3.00

PB67-43001-83

Manufactured No

180

Each

24.0000

1

3

PB67-43001-83

D-Pad Assembly, Short

Location

Loc Qty

Loc Code

Mezz2

24

24

11757

WUE 15-7-13

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DQA: _____ Date: _____

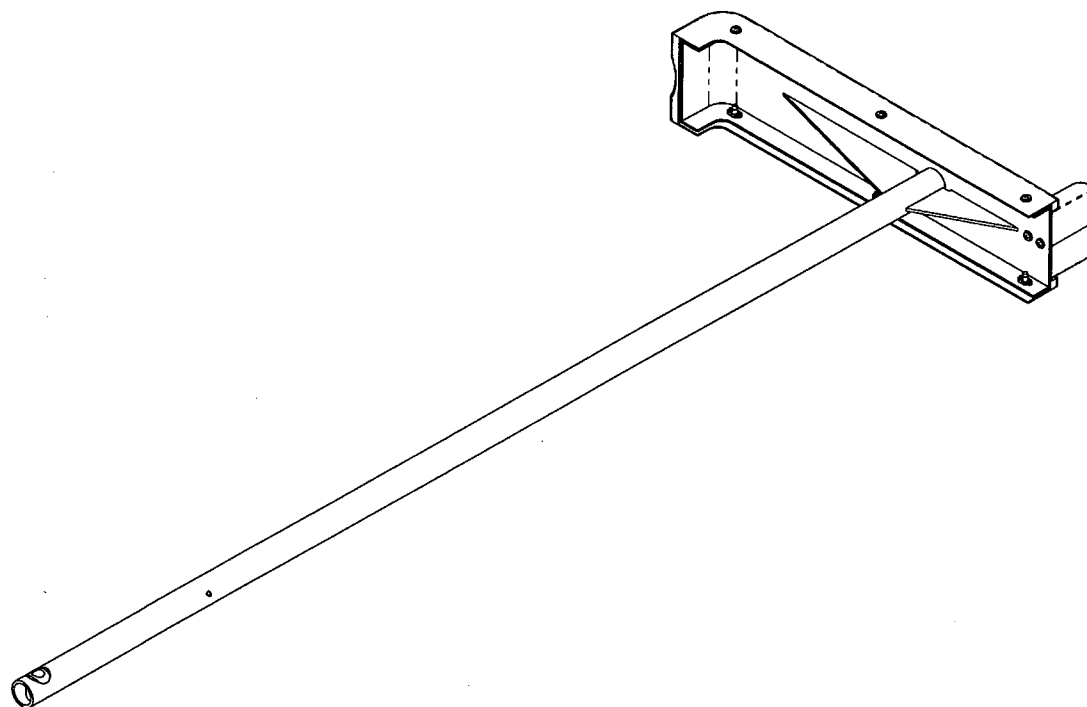


WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="width: 15%;">Skid-tube ☐</td> <td style="width: 15%;">Cross tube ☐</td> <td style="width: 15%;">Water Jet ☐</td> <td style="width: 15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐																				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐																				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐																				
Past Expiry Date ☐	Manufacturing Process ☐																								
Misidentified ☐	Past Due ☐																								
		OTHER : ☐																							



B67-43001-11 FWD ADJUSTABLE BLADE SUPPORT ASSY

ITEM	QTY -11	P/N	DESCRIPTION
1	X	B67-43001-11	FWD ADJUSTABLE BLADE SUPPORT ASSEMBLY
2	1	B67-43001-11W	FWD ADJUSTABLE BLADE SUPPORT WELDMENT
3	1	B67-43001-69	90° COVER PLATE ASSEMBLY
4	1	B67-43001-83	SHORT D-PAD ASSY
5	8	MS27039-1-10	SCREW
6	8	NAS1149D0316J	WASHER
7	6	NAS1149D0363J	WASHER

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NO. 13372-2 MJS
1506-17

RELEASED
2010-09-16
AM

C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO SHEET 8 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011.		MB	10.04.28
REV.	DESCRIPTION		BY	DATE
DESIGN	RW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. B67-43001-11 REV. C SHEET 1 OF 2 TITLE FWD ADJUSTABLE BLADE SUPPORT ASSY SCALE NTS		
DRAWN				
CHECKED				
MFG. APPR.				
APPROVED				
DE APPR.	N/A			
DATE	10.04.28		COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

